

Date: Tuesday, 16/09/2008 3:28:46 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 42041		Part Number	: D3719041		
Estimate Number	: 13107		Drawing Number	: D3719 REVA		
P.O. Number	:		Project Number	: N/A		
This Issue	: 16/09/2008	S.O. No.	Type	Drawing Revision	: A	
Prsh Rev.	: NC		Material	:		
First Issue	: / /	Type	SMALL /MED FAB	Due Date	: 30/09/2008 Qty: 10 Um: Each	
Previous Run	: 36446					
Written By	:					
Checked & Approved By	: JUD 08.9.16					
Comment	: Est Rev :A New Issue 07-12-19 EC verified by DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
Comment: Qty.: 0.5933 sf(s)/Unit Total : 5.9325 sf(s) 304/316 .060 Sheet Batch: 108724 B 8-9-17		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3719 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> B 8-9-17		
2-Deburr if necessary <u>B 8-9-17</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>B 8-9-17</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>S 8-9-18 X40</u>		
Comment: SECOND CHECK		
5.0	D30093	Cup
<u>CUP B 8-9-176</u>		
<u>B 8-9-18 X56</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 42041		Part Number: D3719041
Job Number:		
Seq. #: Machine Or Operation:		Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld D3009-3 cups as per dwg D3719		w/ 316 HTS: M107051
2-Weld hard facing as per Dwg D3719		X/14
A/R	2059B Hard Coat rod	Batch: M109213 EZ 8-9-27
7.0	QC9	VISUAL WELDING INSPECTION
		Cd08-09-25
Comment: VISUAL WELDING INSPECTION		PD 08-09-25 X/14 P10>
8.0	POWDER COATING	POWDER COATING
		M106442 X/14
Comment: POWDER COATING		
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		
START TIME:	8:15	
OVEN TEMPERATURE:	320°	OF
FINISH TIME:	8:45	
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		MF 08/09/26 X/14
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		08-09-26 X/14
10.0	PACKAGING 1	PACKAGING RESOURCE #1
		X/14
Comment: PACKAGING RESOURCE #1		
Identify and Stock		
Location: 500		8/9/26 SP
11.0	QC21	FINAL INSPECTION/W/O RELEASE
		08/09/2008
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		MF 08-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/8/25	# 7.1	Inspect QCS Soldering X16 Permit Change		8/8/25			S 8/8/25

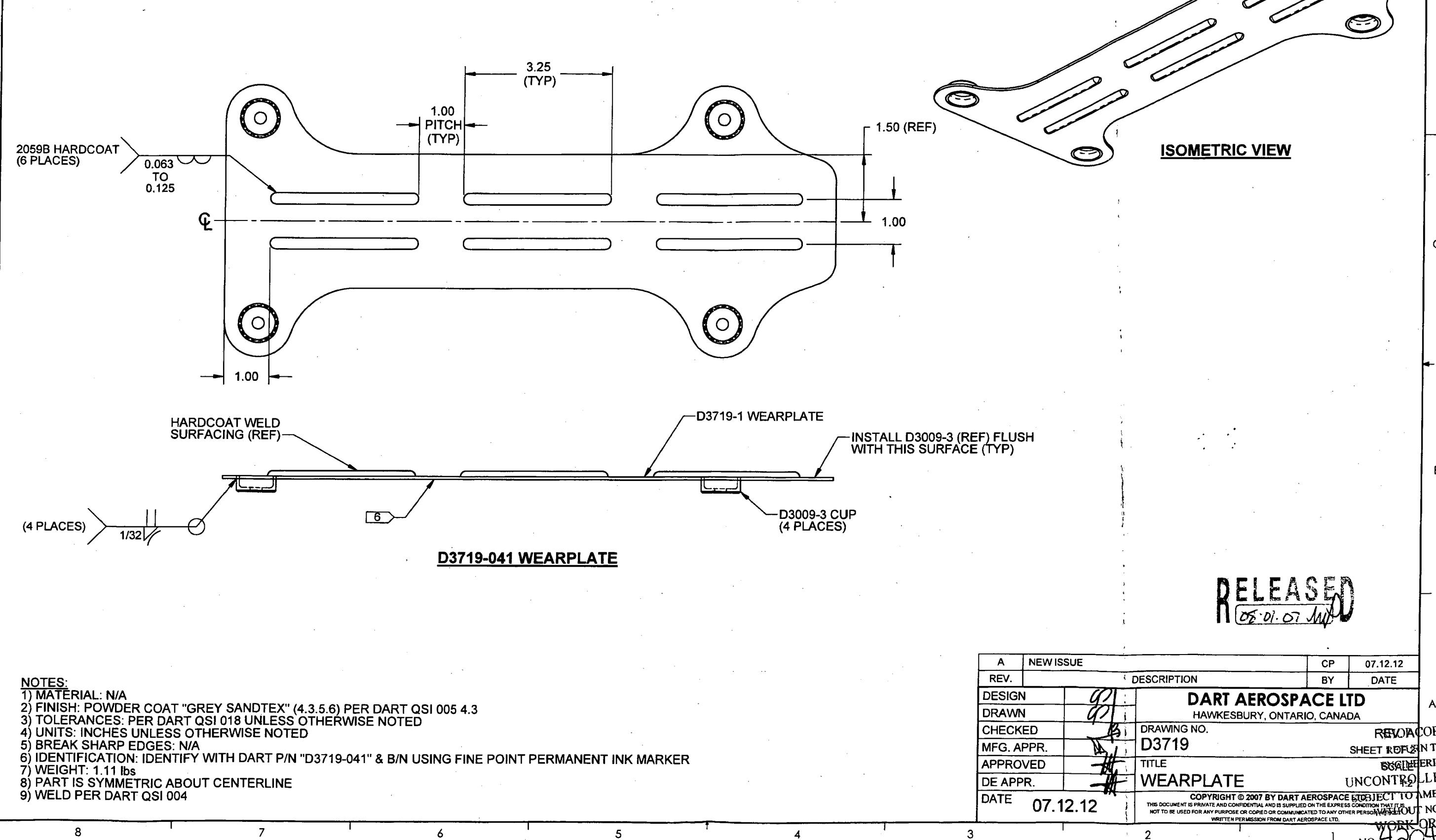
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

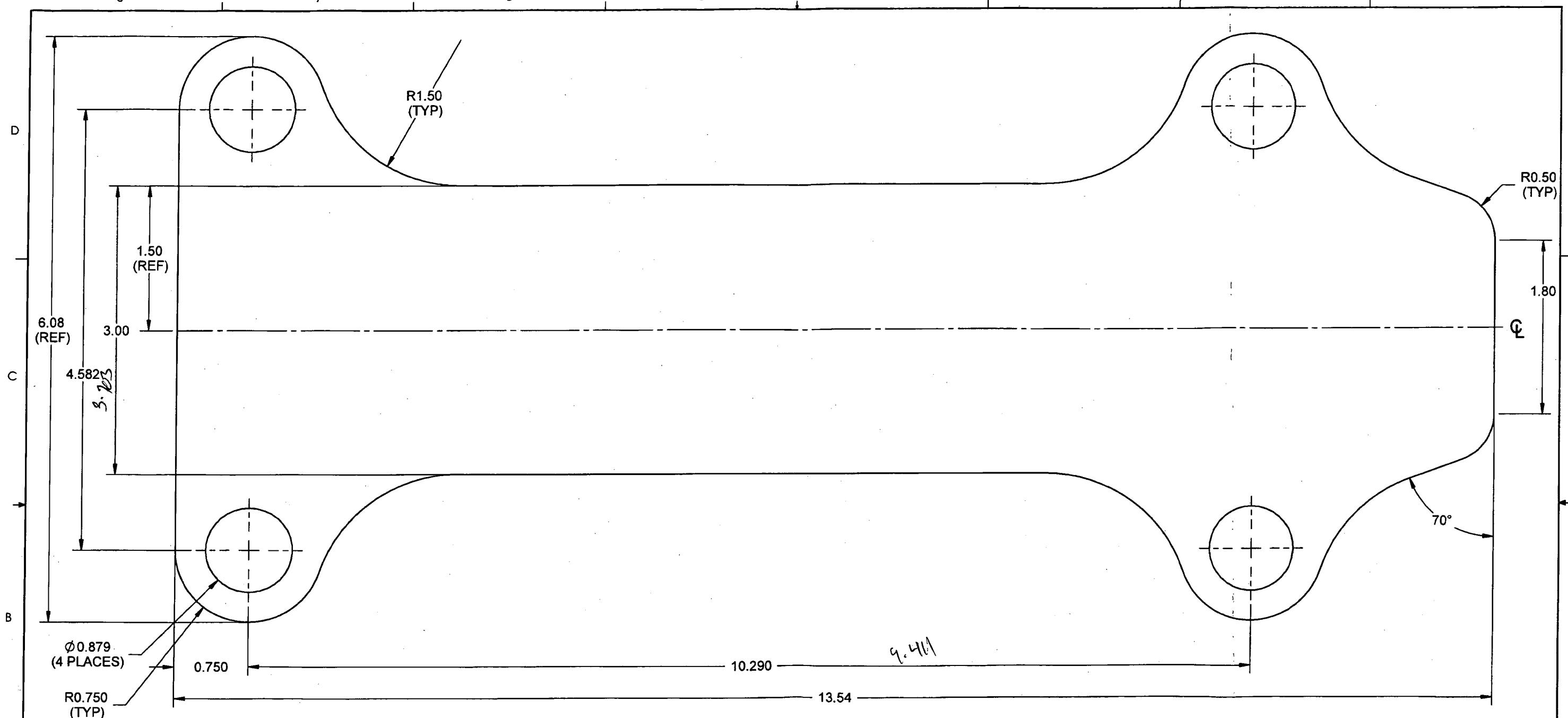
NOTE: Date & initial all entries

QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP



A	NEW ISSUE	CP	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	9/1	DART AEROSPACE LTD	
DRAWN	9/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	REVISION COPY	
MFG. APPR.	DA	SHEET REFERENCE TO	
APPROVED	TH	TITLE	
DE APPR.	TH	ENGINEERING	
DATE	07.12.12	WEARPLATE	
UNCONTROLLED COPY			
SUBJECT TO AMENDMENT			
WITHOUT NOTICE			
WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
08-01-07 JMK



D3719-1 WEARPLATE

RELEASED
08-01-07 TW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.87 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE

DESIGN	99	DART AEROSPACE LTD
DRAWN	99	HAWKESBURY, ONTARIO, CANADA
CHECKED	BS	DRAWING NO.
MFG. APPR.	#	D3719
APPROVED	#	TITLE
DE APPR.	#	WEARPLATE
DATE	07.12.12	COPYRIGHT © 2007 BY DART AEROSPACE LTD. WITHOUT NOTICE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

A
SHOP COPY
REV. RETURN TO
SHEET 2 OF 2
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WITHOUT NOTICE
WORK ORDER
NO. 40041

DART AEROSPACE LTD	Work Order:	42041
Description: WEAR PLATE	Part Number:	D3719-1
Inspection Dwg: 3719-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: KB	Audited by: J	Prototype Approval: A
Date: 8-9-17	Date: 08/09/17	Date: A

Rev	Date	Change	Revised by	Approved
A		New Issue PJO D3719-041	KJ/JLM	